

5/13

SLIT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22519 P
<b>Description:</b> Folding Step Weldment RH	<b>Part Number:</b>	D3388-042 10
<b>Dwg:</b> D3388 Rev. A	<b>Qty:</b>	20 10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	AF	05.02.23	20
2	GA	Cut D2622-120C extrusion 85.15" long as per Dwg D3388 Batch: B21640 10	PD	05.03.07	10
3	GA	Deburr and bevel ends for welding	LE	05.06.3	10
4	WA	Weld arms and end caps as per Dwg D3388. Inspect for foreign objects as per QSI 024. <b>Pick:</b> Qty Part Number Description Batch 2 D2734 End Cap 20 B20757 2 D3387-042 2 Arm B22528 6	LE	05.06.3	10
5	GA	Grind end cap welds flush	LE	05.06.6	10
6	QC9/5	Inspect weld and work to Step 5	LE	05.06.16	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FC	05.06.23	10
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.06.29	10
9	FP	Wing Walk as per Dwg D3388 and QSI 005 4.4	MM	05.06.29	10
10	QC3	Inspect Powder Coat and Wing Walk	LE	05.07.25	10
11	ST	Identify and Stock	LE	05.07.25	10
12	AC	Cost / part: 167.25	SQC	05.08.02	10
13	DC	Close W/O 167.25 Inspect Level 21	LE	05.07.25	10

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	

D2808

Spec 10 B22542

05.07.25  
05.02.23  
RECEIVED



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	4	Add as shown & update BOM.	<i>[Signature]</i>				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

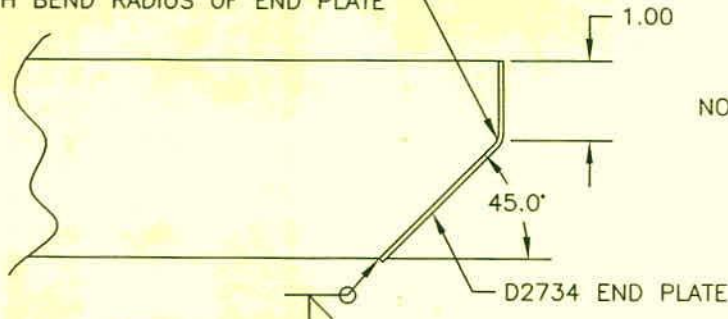
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/07/25

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



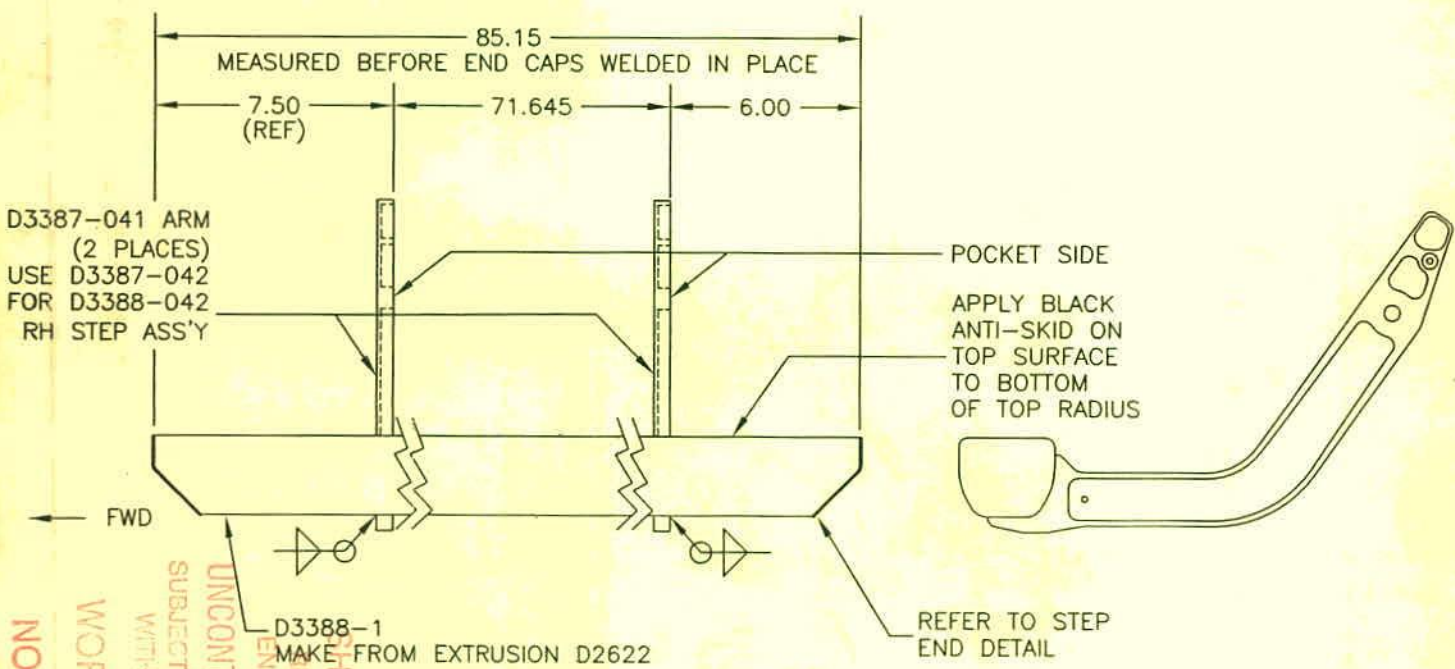
# PRELIMINARY ISSUE

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



NOTE: ALL WELDS SHALL BE 100%  
VISUALLY INSPECTED BY A  
QUALIFIED INSPECTOR PER  
DART QSI 004

TYPICAL STEP END DETAIL  
NOT TO SCALE



**D3388-041 LH STEP ASSEMBLY (SHOWN)**  
**D3388-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	APPROVED	DRAWING NO.	REV. A
CHECKED	APPROVED	D3388	
DATE	TITLE	STEP WELDMENT	SHEET 1 OF 1
05.01.20			SCALE
A	05.01.20	NEW ISSUE	NIS

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

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WORK ORDER  
NO. 22519

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022519  
Project Name : D3388-042  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3388-042  
Description : Step Weldment RH  
Manufactured : No  
Amount Req'd : *820*  
Amount Done : 0  
Start Date : 02-22-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00